

Date: Wednesday, 3/26/2008 9:33:36 AM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	END CAP		
Job Number	38144					
Estimate Number	11877					
P.O. Number			Part Number	D2208		
This Issue	3/26/2008	S.O. No.	Drawing Number	D2208 REV C		
Prsht Rev.	NC		Project Number	N/A		
First Issue	/ /	Type	Drawing Revision	C		
Previous Run	37743		Material			
Written By			Due Date	4/1/2008	Qty:	20
Checked & Approved By	<u>JO 08.3.26</u>		Um:	Each		
Comment	Est A 01.03.08 New Issue Est B 07.09.11 ecn 998 EC verified by: JLM					

Additional Product

Job-Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6S063	6061-T6 .063 Sheet 45
Comment:	Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s) 6061-T6 .063 Sheet 5052-H32 or 6061-T6 - .063" Thick Batch <u>107387</u> <u>RB 8-3-31</u>	
2.0	WATER JET	FLOW WATER JET <u>RB 8-3-31</u>
Comment:	FLOW WATER JET 1-Cut as per Dwg D2208 Dwg Rev: <u>C</u> Prog Rev: <u>C</u>	<u>59</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <u>RB 8-3-31</u>
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK <u>508/03/31 (X28)</u>
Comment:	SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1 <u>STEVE</u>
Comment:	PACKAGING RESOURCE #1 Identify and Stock Location: <u>STEVE</u>	<u>PC 8/3/31 (29)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END CAP

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/03
JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mF

08-08-31

W

END OF SHEET

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38144
Description: End Cap	Part Number:	D2208
Inspection Dwg: D2208	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

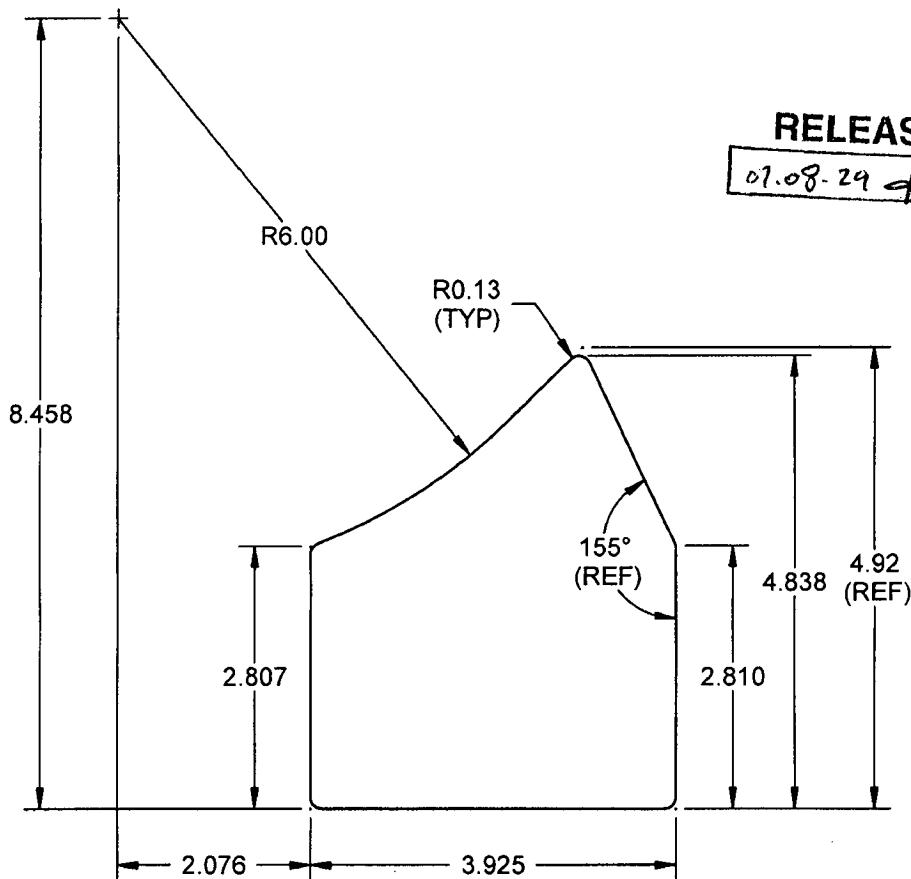
X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-3-31	Date:	08/03/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue P/O D206-539-013	KJ/JLM	
B	07.07.17	Dimensions updated per Dwg Rev. C	KJ/JLM	

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>JM</i>	DRAWING NO. D2208	REV. C	SHEET 1 OF 1
DATE 07.07.05	TITLE END CAP		SCALE 1:2	
REV A	DATE 94.09.01	DESCRIPTION NEW ISSUE		
B	01.02.22	REDRAWN		
C	07.07.05	REDESIGN		



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38144

D2208 END CAP

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX